



Dart Hawkesbury
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Hawkesbury, ON
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Tel (613) 632-5200

D4273-041
Job Sheet 168127



Part No: D4273-041

Job Qty: 1 ea

Part Name: Basket Base Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/9/17

Job Tracking No:

Due Date: 12/22/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/21/17	12/21/17	0.00	0.00	Start Up Large Fab2		D.M.L 17-12-1
100	Large Fab	1 pcs	12/21/17	12/21/17	0.00	20.83	Large Fab 1		C.L 17-12-1
110	QC	1 pcs	12/21/17	12/21/17	0.00	0.00	QC9		PD 17-12-4
120	QC	1 pcs	12/21/17	12/21/17	0.00	0.00	QC5		PD 17-12-4
125	HandFinish	1 pcs	12/21/17	12/21/17	0.00	0.35	HandFinish2		PD 17-12-11 B.E.B.
130	Powdercoat	1 pcs	12/22/17	12/22/17	0.00	0.66	Powdercoat2		PD 17-12-11
140	QC	1 pcs	12/22/17	12/22/17	0.00	0.00	QC3		PD 17-12-11
150	Packaging	1 pcs	12/22/17	12/22/17	0.00	0.00	Packaging3		PD 17-12-11
160	QC21-SA	1 Ea	12/22/17	12/22/17	0.00	0.00	QC21		DEC 14 2017

Part Op 100 - 1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION E-E ON PAGE 2 DWG D4273, NEED Descriptions: TO WELDED AFTHET MESH IS INSTALL) weld as per dwg D4273 using DT9610A ***visual inspect before welding mesh*** 2- Cut D4279-1 base mesh (MADE ON THIS W/O) and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends (D4279-5/-9)

130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat

M139467 START: 2:35 O.U.T: 3:35 FINISH: 2:50

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581 S005842	2	107	0	0
	D3913-1 S002297	1	13	0	0
	5014390 D3913-15 H01922	1	8	0	0
	D3913-3 S002108	1	16	0	0
	D3913-9 S005010881	1	7	0	0
	D3916-5 S009914	3	15	0	0
	D4016-18 S009181	3	4	0	0
	D4017-7 S004770	3	52	0	0
	D4021-1 166089	3	23	0	0
	D4034-041 H08 S012764	1	6	0	0
	D4277-19 164527	1	5	0	0
	D4277-3 164571	1	6	0	0
	D4277-5 S0019176	2	8	0	0
	D4277-9 164520	1	6	0	0
	D4278-045 S011234	2	2	0	0
	D4278-047 164525	1	3	0	0
	5000701 D4279-5 S001976	1	14	0	0
	D4279-7 S005859	2	17	0	0
	D4279-9 166707	1	2	0	0
	D4306-043 164394	1	1	0	0
	D4306-045 164515	1	9	0	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

D4306-1	S013123	1	12	0	0
D4672-1	S058166	2	52	0	0
M304EX0.75-16F	S00986332	32	547	0	0

Part Specifications

Specifications could not be found.

Plex 11/9/17 4:41 PM dart.poulin.mario

DART
AEROSPACE
S015100

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Basket Base Assembly, LH

PART NO: D4273-041
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 11/29/17
Job No: 168127

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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